



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3572-041
Job Sheet 197825



DAS
21
9-89

Part No: D3572-041

Job Qty: 6 pcs

Part Name: Guide



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/17/19

Job Tracking No:

Due Date: 8/16/19

Created By: Marie Lajeunesse

Type: Stock

Description: SIOP

Note: DWG REV D IPP Rev:A New Issue 07-02-07 JLM IPP rev B revB dwg EC IPP Rev:C Removed D3572-7 Cap
07-06-11 JLM IPP Rev:D 08-05-27 Review process of IPP DD verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Large Fab - Welded Assy-1	6 pcs	8/16/19		0.00	1.63	Large Fab - 1		EL
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various).		
120	QC 5	6 pcs	8/16/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
							QC 5 - 81		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S222875



Part: D3572-041

Job No: 197825

Serial No/Batch: S222875

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 10/16/19

130 Large Fab - Welded Assy-2-B4B	6 pcs	8/16/19	0.00 5.83	Large Fab - 1 - B4B	
				Large Fab - 10 - B4B	
				Large Fab - 2 - B4B	
				Large Fab - 3 - B4B	
				Large Fab - 4 - B4B	
				Large Fab - 5 - B4B	
				Large Fab - 6 - B4B	
				Large Fab - 7 - B4B	
				Large Fab - 8 - B4B	
				Large Fab - 9 - B4B	
				Large Fab - 11 - B4B (Various)	
140 QC 9	6 pcs	8/16/19	0.00 0.00	QC 9 - 10	
				QC 9 - 18	DAS 24 9-89
				QC 9 - 24	
				QC 9 - 43	
				QC 9 - 50	
				QC 9 - 9	
150 QC 5	6 pcs	8/16/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	DAS 24 9-89
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
180 Handfinish - 1-1 Chemical-B4B	6 pcs	8/16/19	0.00 0.55	Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	★ 6107 / L 130
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	

190	Powdercoat - 3 Grey Sand - B4B	6 pcs	8/16/19	0.00 0.39	Powdercoat - 1 - B4B	
					Powdercoat - 2 - B4B	
					Powdercoat - 3 - B4B	BL 19-10-18.
					Powdercoat - 4 - B4B	
200	QC 3	6 pcs	8/16/19	0.00 0.00	QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	M/D
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	
					QC 3 - 19	
					QC 3 - 43	
					QC 3 - 24	
					QC 3 - 61	
					QC 3 - 81	
210	Packaging 3-1 - Stock - B4B	6 pcs	8/16/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	M/D
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	

				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
220 QC 21 - SA	6 pcs	8/16/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 53	

Part Op 110 - 1-Cut Tube D3572-1 as per Dwg D3572 2-deburr both ends
 Descriptions: 120 - (QC5- Inspect part completeness to step on W/O)
 130 - (Weld per dwg A/R Aluminum rod Batch: M134285 USE DT8947 DT8944*** 1-Weld D3572-5 bracket to D3572-1 as per Dwg D3572 2- Grind weld flush at the end of tube only 3- Weld D3572-3 guides to D3572-1 as per dwg
 140 - (QC9- Inspect visual per QSI004- Fusion Welds)
 150 - (QC5- Inspect part completeness to step on W/O)
 180 - (Chemical Conversion Coat per QSI005 4.1)
 190 - (Grey Sandtex (Ref:4.3.5.6) per QSI005 4.3) START TIME: 1:00 OVEN TEMPERATURE: 320°
 FINISH TIME: 2:00 M135839
 200 - (QC3- Inspect Part Finish)
 210 - (Identify as per dwg & Stock Location: _____)
 220 - (QC21- Final Inspection - Work Order Release)

DAS 21
8-39
OCT 23 2019

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M6061T6T1.000W.188	6061T6 Round Tube 1.00 X .188W	14.0400 ft (2.34 ea)	110-Large Fab - Welded Assy-1	<u>5200701</u>
D3572-3	Guide	24 pcs (4 ea)	130-Large Fab - Welded Assy-2- B4B	<u>5081694</u>
D3572-5	Bracket	6 pcs (1 ea)	130-Large Fab - Welded Assy-2- B4B	<u>5088893</u>

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Large Fab - Welded Assy-1	M6061T6T1.000W.188	14	22	0
130-Large Fab - Welded Assy-2- B4B	D3572-3	24	52	0
	D3572-5	6	9	0

Part Specifications	
Specifications could not be found.	

Plex 7/17/19 11:02 AM Dart.lajeunesse.marie

